

Date: Tuesday, 21/04/2009 4:01:07 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PEDAL LOCK BASE
Job Number :	47344		
Estimate Number :	11345		
P.O. Number :		Part Number :	D33701 FR
This Issue :	21/04/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3370 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	45791	Drawing Revision :	C
	Type :	Material :	
	MACHINED PARTS	Due Date :	10/05/2009
Written By :		Qty:	6
Checked & Approved By :	<u>JULIE DAWSON</u>	Um:	Each
Comment :	Est. B 05.05.25 Added Powder Coat KJ/JLM Est Rev:C 08-07-17 revC as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1500X02500	6061-T6 Bar 1.50 x 2.50
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(6)

Comment: Qty.: 0.3657 f(s)/Unit Total: 2.1943 f(s)
 6061-T6 Bar 1.5" x 2.5"

X-4-125 1.071

M6061T6

HARDINGE

HAAAS #1

HARDINGE CNC LATHE SMALL



(6)

Comment: Machine D3368-1 as per Folio FA499 and Dwg D3368
 Identify as D3368-1
 Deburr

H.A 09/04/25

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(6)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 09/04/25

4.0	QC8	SECOND CHECK
-----	-----	--------------



(6)

Comment: SECOND CHECK

md/BR 09/04/26

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(6)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

md/BR

09/04/27

6.0	POWDER COATING	POWDER COATING
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(6)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

9:00

md/BR

09/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 21/04/2009 4:01:07 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK BASE

Job Number: 47344

Part Number: D33701

Job Number:



Seq. #:

Machine Or Operation:

Description :

OVEN TEMPERATURE: 320°

FINISH TIME: 9:30

mmv FL

09/05/01

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST491

SS 09/05/01 (X6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/12 (X6)

Job Completion



MF 09-05-11

W3 Inspect & loadie / part MF 09-05-01 (X6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 49344
Description: Pedal Lock Base		Part Number: D3370-1
Inspection Dwg: D3370	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓			
0.202	+/-0.010	0.202	✓			
0.592	+/-0.010	0.592	✓			
0.550	+/-0.010	0.550	✓			
0.760	+/-0.010	0.760	✓			
1.50	+/-0.030	1.497	✓			
1.188	+/-0.010	1.188	✓			
1.232	+/-0.010	1.224	✓			
R0.500	+/-0.010	R0.500	✓			
2.35	+/-0.030	2.349	✓			
1.920	+/-0.010	1.917	✓			
0.450	+/-0.010	0.449	✓			
1.673	+/-0.010	1.671	✓			
2.638	+/-0.010	2.6355	✓			
4.00	+/-0.030	3.999	✓			
Ø0.203	+0.005/-0.000	Ø0.207	✓			
0.250	+/-0.030	0.247	✓			
1.450	+/-0.005	1.449	✓			
0.450	+/-0.010	0.450	✓			
15°	+/-0.1°	15°	✓			

Measured by: K.A	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/04/25	Date: 07/04/26	Date: N/A

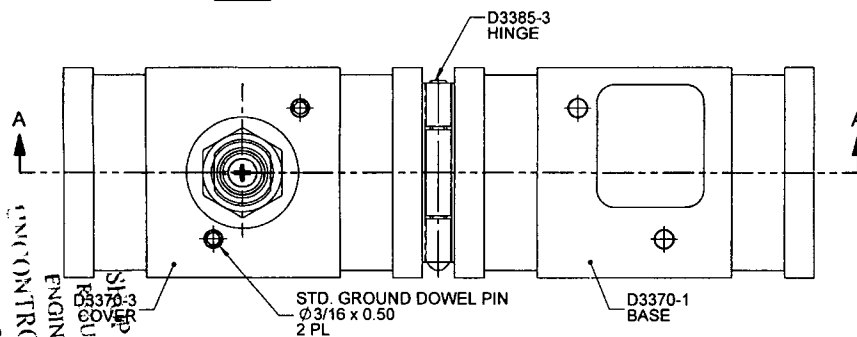
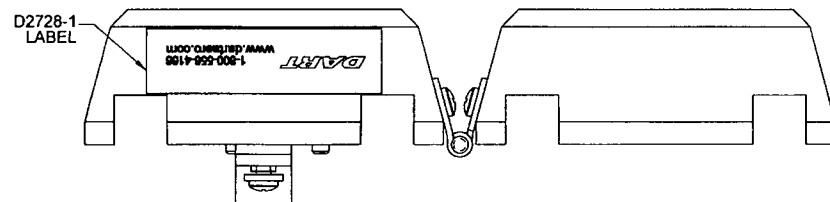
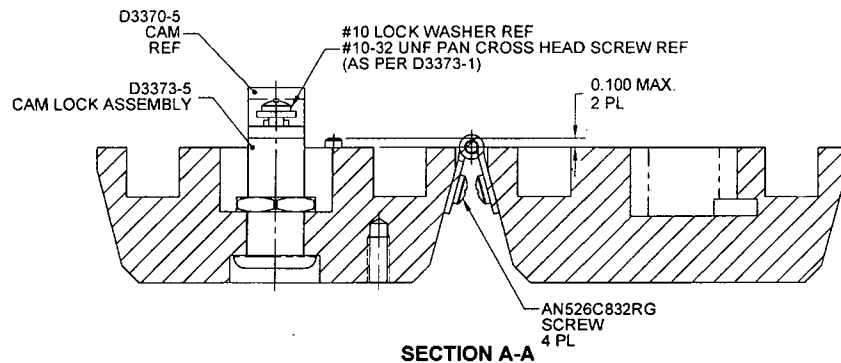
Rev	Date	Change	Revised by	Approved
A	05.01.05	New Issue	KJ/JLM	
B	05.04.26	Revised dimensions	KJ/JLM	
C	05.05.25	Revised dimensions	KJ/JLM	[Signature]

Qty. -041	Qty. -051	PART NUMBER	DESCRIPTION
X		D3370-041	TAIL ROTOR DISABLING KIT
1	X	D3370-051	PEDAL LOCK
1		D3384-041	CYCLIC SOCK
1		HX-81	1/4-20 SOCKET HEAD CAP SCREW
2		AN960-416	WASHER
1		D2728-7	LABEL
1		D3370-1	BASE
1		D3370-3	COVER
1		D3373-5	CAM LOCK ASSY
1		D3385-3	HINGE
2		Ø 3/16 X 0.50 GROUND STUD DOWEL PIN	GROUND STUD DOWEL PIN
4		AN526C832R6	SCREW

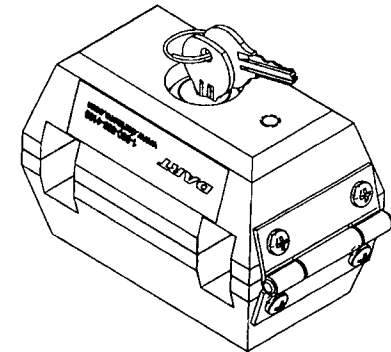
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NO. 1234

C	SHEET 1 ADDED P/L. ADDED -041 TO P/L (SEE NCR 264). DRAWING TRANSFERRED TO "B" SIZE FORMAT. REFORMATTED TO CURRENT STANDARDS.	AJS	08.07.11
B	D3385-3 WAS D3385-1	MB	05.03.22
A	NEW ISSUE	RF	04.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	08.07.11	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIES OR REPRODUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3370-051 PEDAL LOCK ASSEMBLY

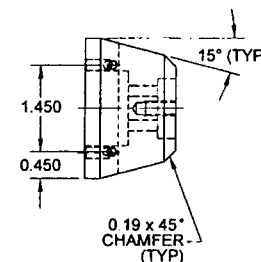
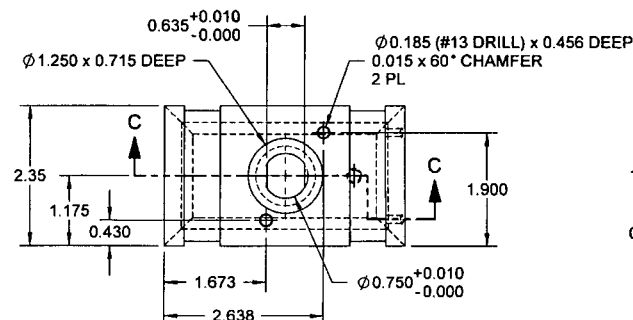
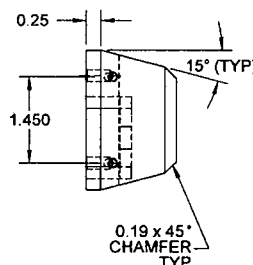
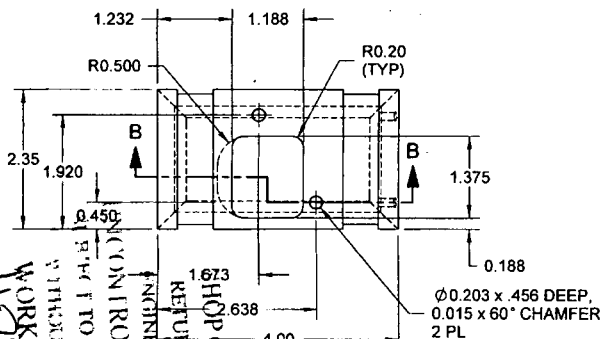
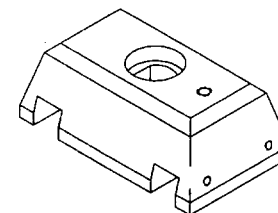
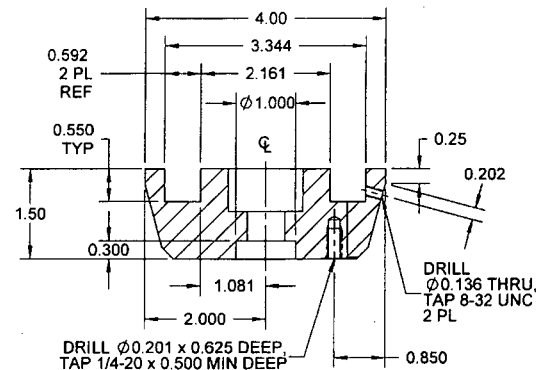
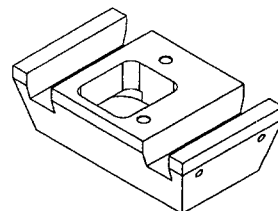
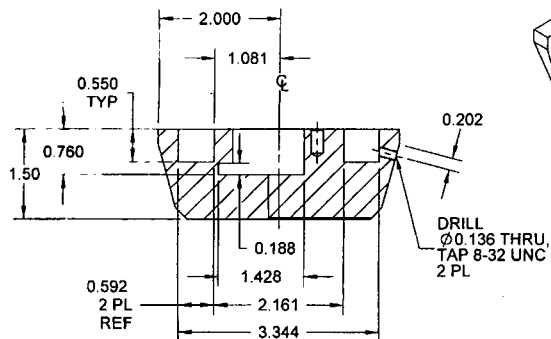


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COVER

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.75 lbs

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3370	SHEET 2 OF 4
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DE APPR.		PEDAL LOCK	NTS
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D3370-3 COVER

D3370-1 BASE





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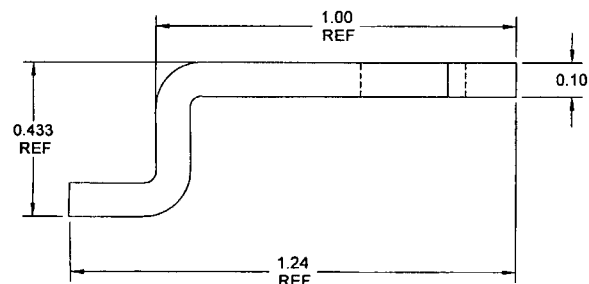
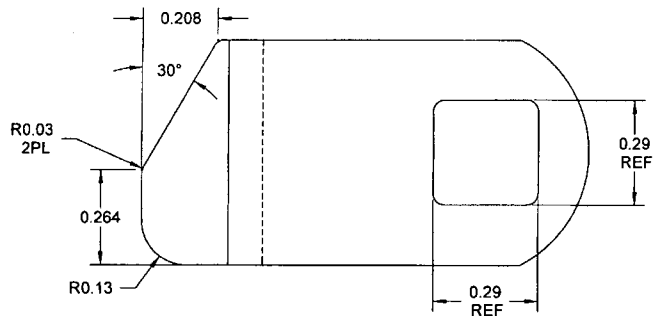
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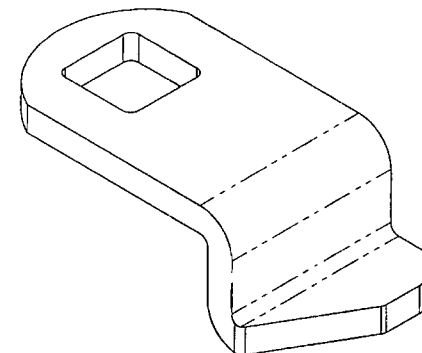
FOR AMENDMENT

- NOTES
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) REF. DART SPEC. M6061T6B
 - 2) COVER INSIDE HOLES PRIOR PAINTING
 - 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED		DRAWING NO.	REV. C
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D3370-5 CAM



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NOTICE

- NOTES:
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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